

Date: Monday, 07/07/2008 8:36:20 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FRONT OUTBOARD LEG (LH)
<b>Job Number</b> :	40313		
<b>Estimate Number</b> :	13376		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37683
<b>This Issue</b> :	07/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3768 REVA
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :		<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	30/07/2008
<b>Written By</b> :		<b>Qty:</b>	3
<b>Checked &amp; Approved By</b> :	JUL 08.7.07	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T1000W065	6061T6 TUBE
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**Comment:** Qty.: 0.8969 f(s)/Unit Total : 0.8969 f(s)  
 6061T6 TUBE (1.00" x 0.65" wall)  
 batch: M 001234

Re 08/07/08

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------

**Comment:** Doosan Lathe

1- Turn as per Folio FA757 Rev: A & Dwg D3768 Rev: A

2-Deburr per dwg D3768

Re 08/07/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Re 08/07/08

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

J-F - 08/07/09 (3)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

HS

08-07-09

(23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 07/07/2008 8:36:21 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (LH)

Job Number: 40313

Part Number: D37683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 18052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

8:00am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:30am

MF 08-07-15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



3X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/07/15

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57115 / 10 8/15 (3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

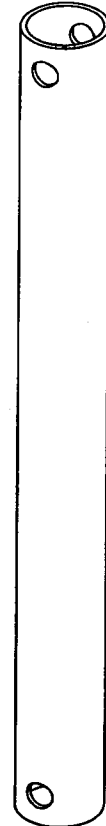
1

D

C

B

A



**D3768-1 FRONT INBOARD LEG****D3768-3 FRONT OUTBOARD LEG, LH****D3768-4 FRONT OUTBOARD LEG, RH**

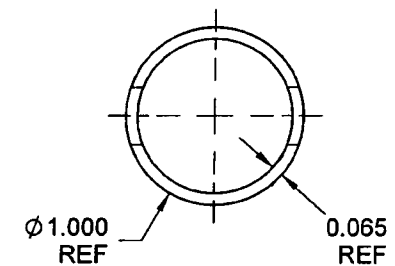
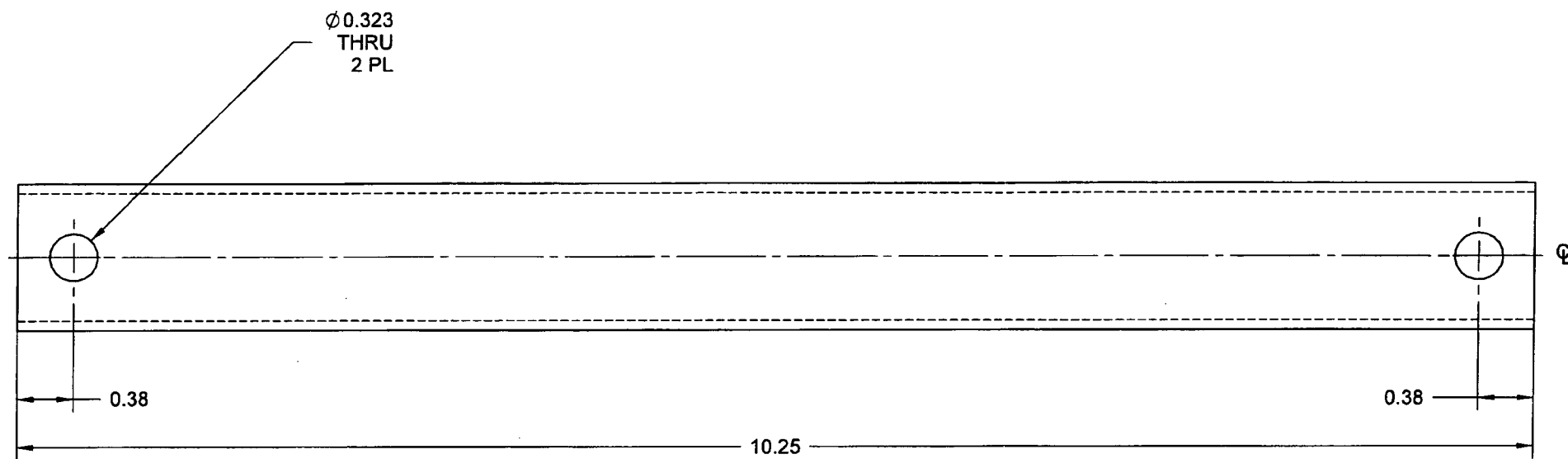
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WORK ORDER  
NO. 40313

**RELEASED**  
08.06.16

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
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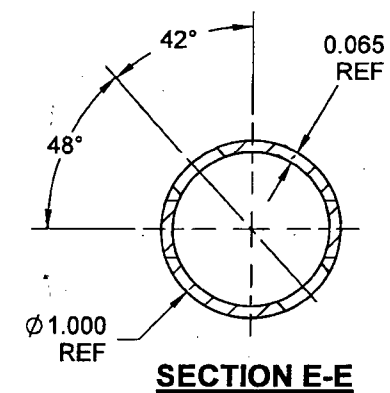
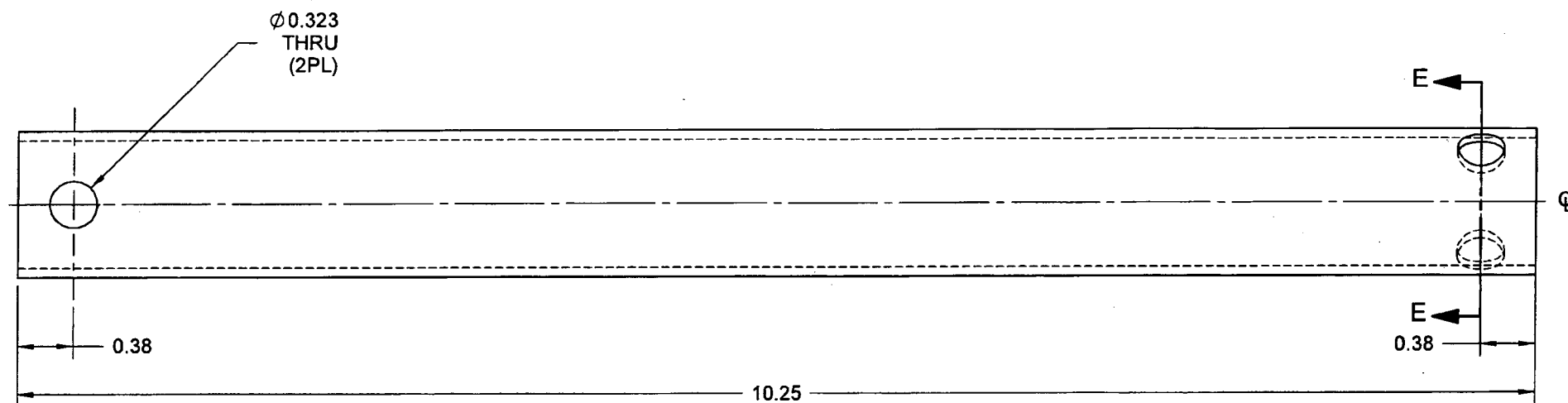


**D3768-1 FRONT INBOARD LEG**

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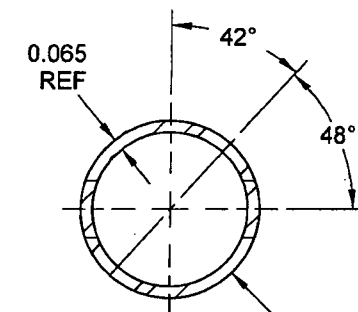
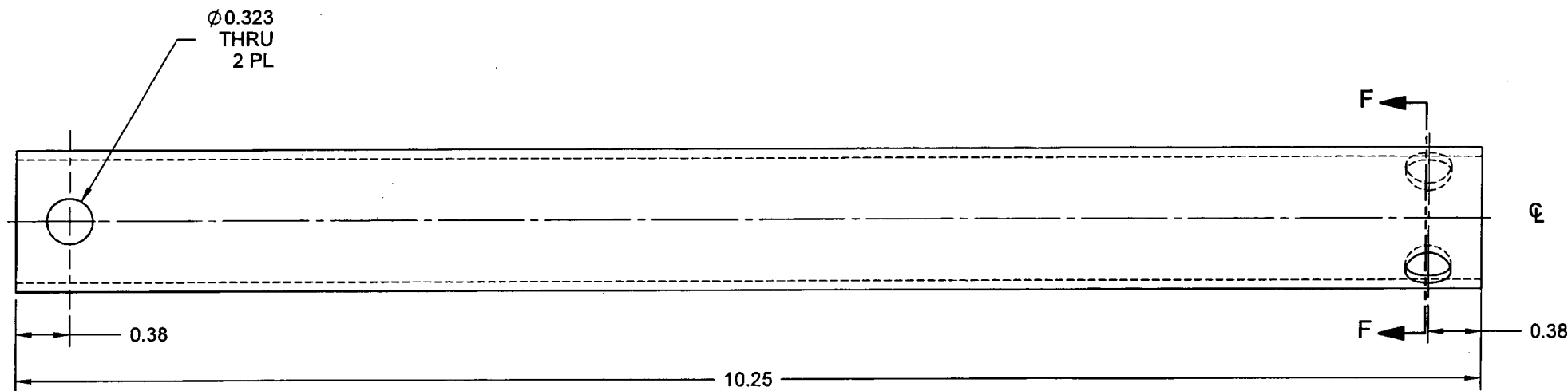


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**D3768-4 FRONT OUTBOARD LEG, RH**

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DART AEROSPACE LTD		Work Order: 40313
Description: Crosstube Assembly <del>Front Outboard Leg</del> , LH		Part Number: D3768-3
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.323	+1.006 - .001	.325			
	.38	+/- .020	.38			
	10.25	+/- .030	10.24			
	.38	+/- .030	.375			
	42°	+/- 1/2°	42°			
	48°	+/- 1/2°	48°			
	1.000	+/- .010	1.000			
	.065	+/- .010	.064			
SIDE B						

Measured by: <i>RP</i>	Audited by: <i>J.F.</i>	Prototype Approval:	N/A
Date: <i>08/07/08</i>	Date: <i>08/07/09</i>	Date:	N/A
Rev A	Date	Change	Revised by
		New Issue	KJ/JLM
			Approved